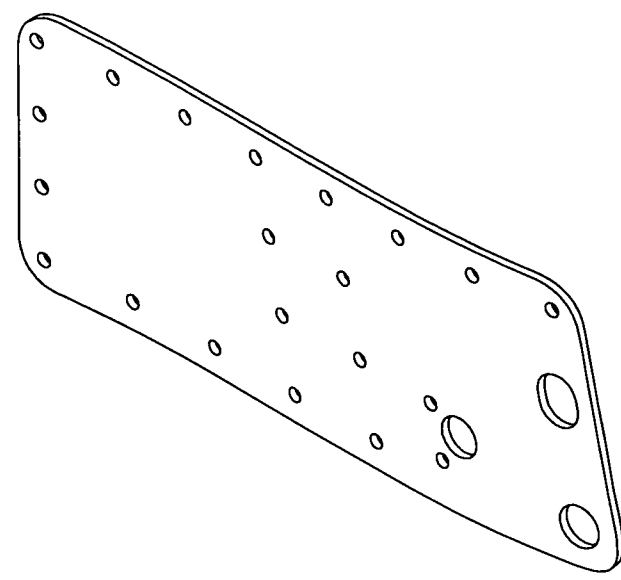
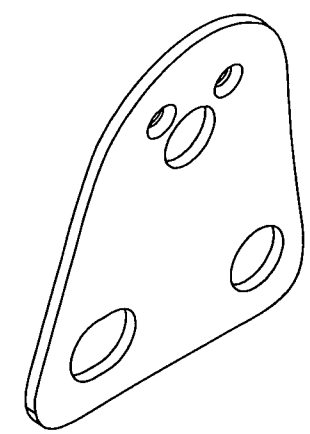


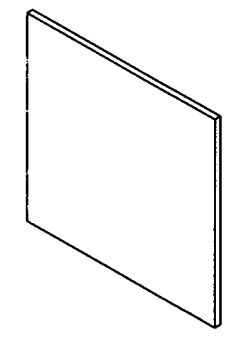
**D4108-1 LEFT PASS DOOR DOUBLER**



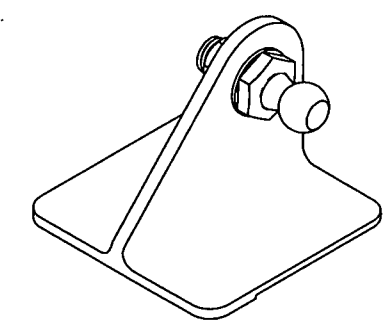
**D4108-3 RIGHT PASS DOOR DOUBLER**



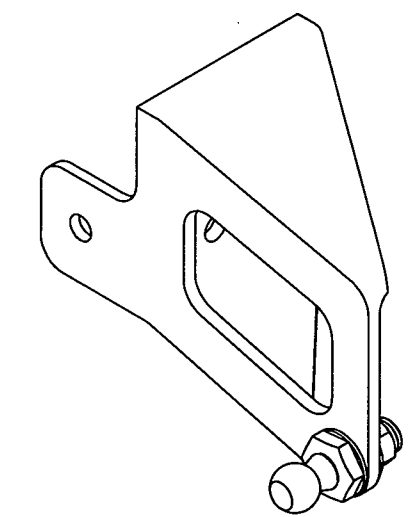
**D4108-5 SMALL RIGHT DOOR DOUBLER**



**D4108-11 TEMPLATE**



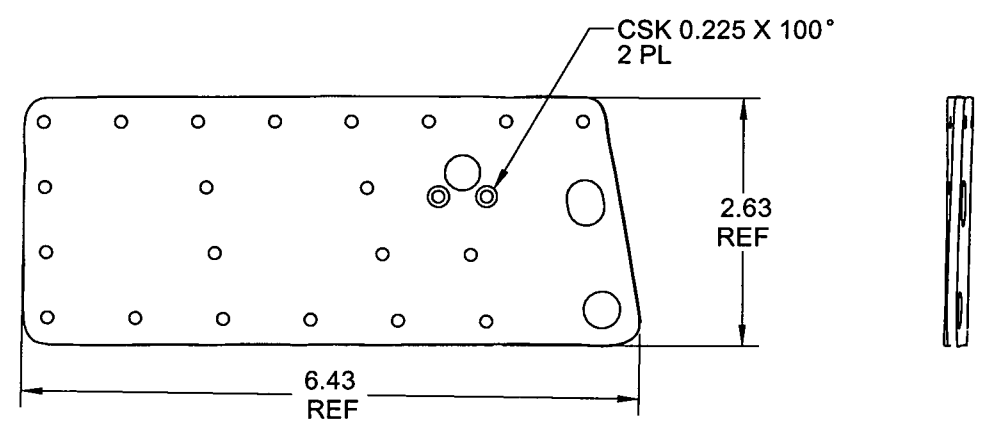
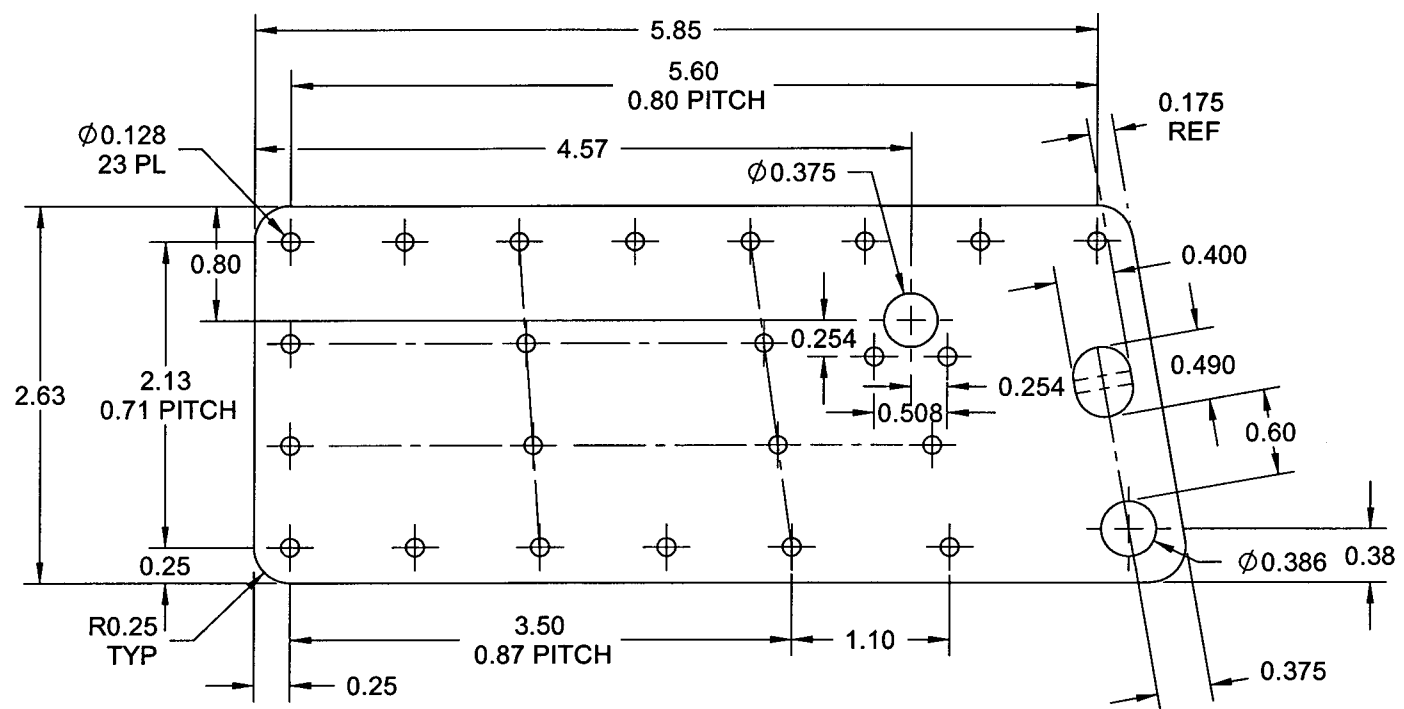
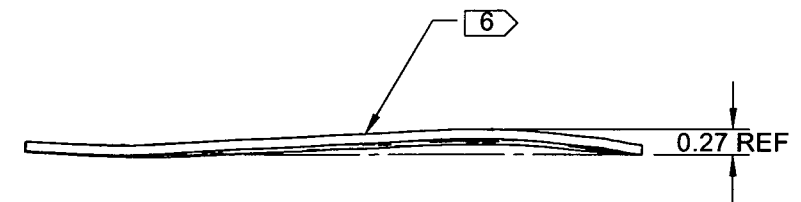
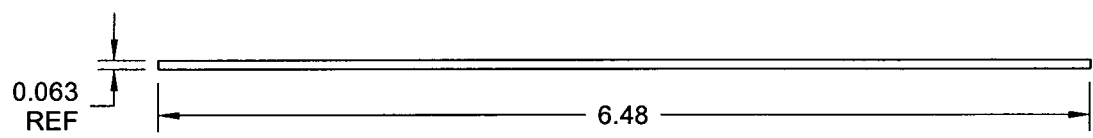
**D4108-047 SILL BRACKET ASSEMBLY**



**D4108-049 LITTER DOOR FITTING ASSEMBLY**

**RELEASED**  
2010-11-30

B	D4108-5 (ZN C4-1 & B4-4) VIEWS UPDATED. D4108-7/-9 MTL CHANGED TO 6061-T6 AL. NOTES UPDATED (SHT 5,6)	JPH	10.11.01
A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4108</b>	
MFG. APPR.	<i>[Signature]</i>	REV. B SHEET 1 OF 7	
APPROVED	<i>[Signature]</i>	TITLE <b>DOUBLERS &amp; FITTINGS</b>	
DE APPR.	<i>[Signature]</i>	SCALE NTS	
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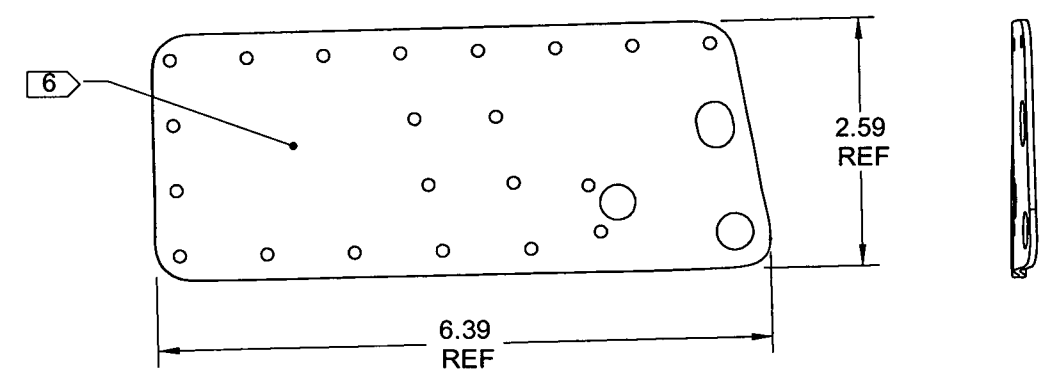
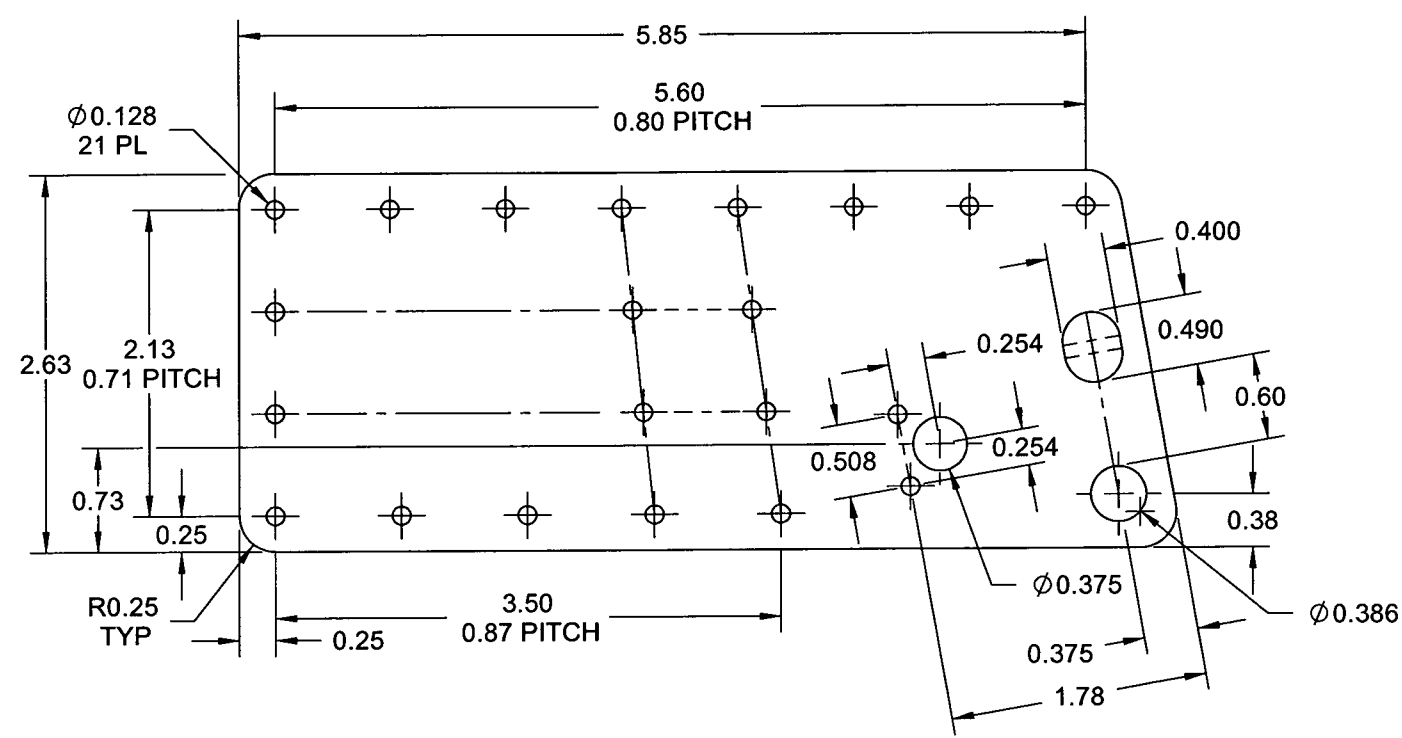
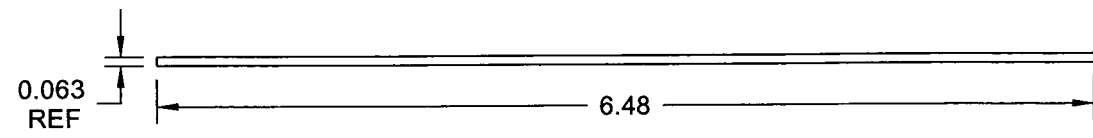
**D4108-1 LEFT PASS DOOR DOUBLER** 8  
(MAKE FROM D4108-1F)

**D4108-1F FLAT PATTERN, LEFT PASSENGER DOOR DOUBLER**

- NOTES:**
- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA  
-1 : MAKE FROM D4108-1F.
  - 2) FINISH: NONE.
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: -1: P/N D4108-1 & B/N PER QSI 044 6.1
  - 7) WEIGHT: 0.29 lbs
  - 8) FORM & INSPECTION PER TEMPLATE DT9648.

RELEASED  
2010-11-30  
WP

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MFG. APPR.	<i>[Signature]</i>	<b>D4108</b>	SHEET 2 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>DOUBLERS &amp; FITTINGS</b>	NTS
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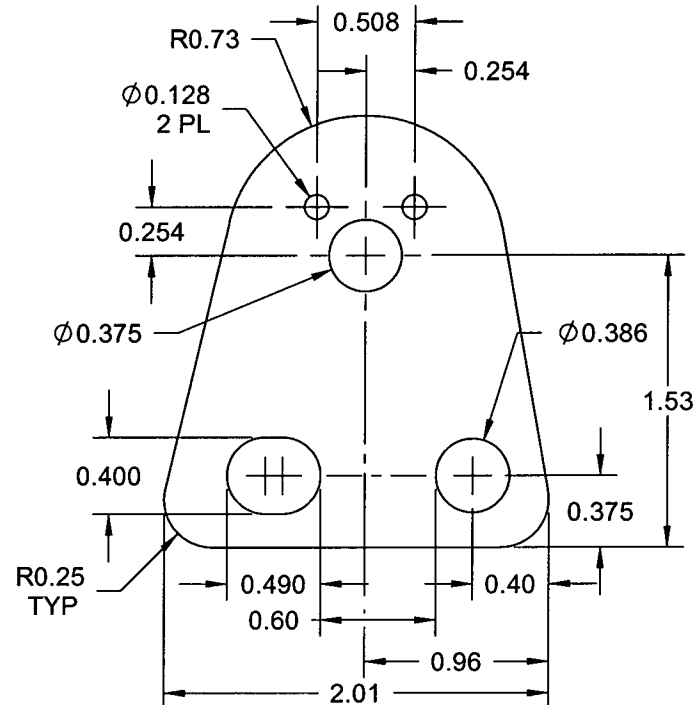
**D4108-3F FLAT PATTERN, RIGHT PASSENGER DOOR DOUBLER**

**D4108-3 RIGHT PASS DOOR DOUBLER (MAKE FROM D4108-3F)**

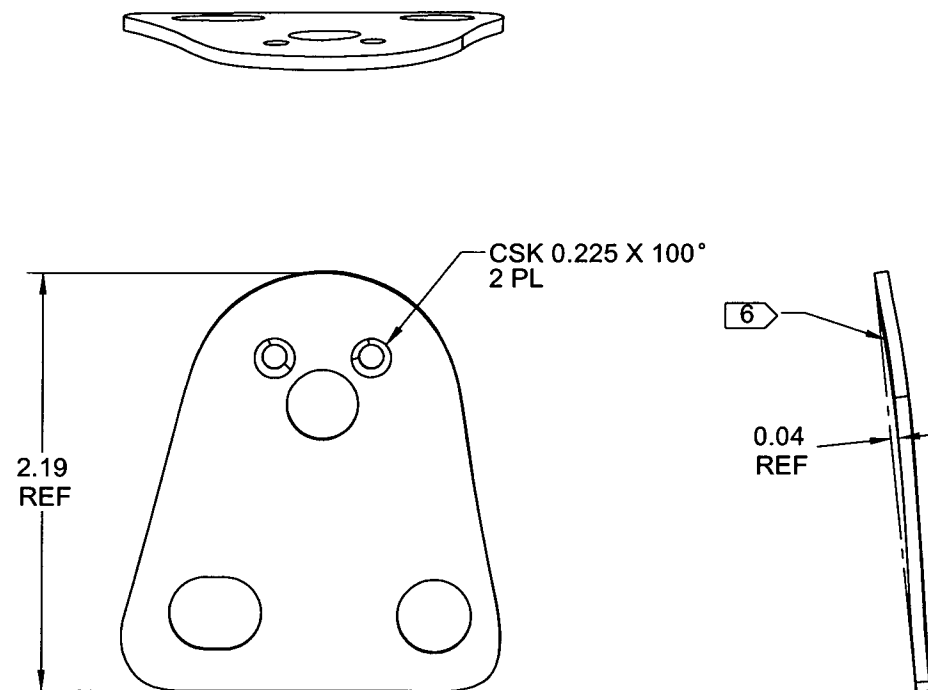
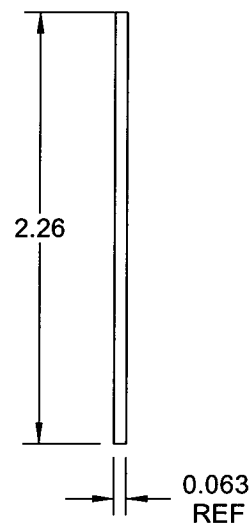
- NOTES:**
- 1) MATERIAL -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA  
-3: MAKE FROM D4108-3F.
  - 2) FINISH: NONE.
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: -3: P/N D4108-3 & B/N PER QSI 044 6.1
  - 7) WEIGHT: 0.29 lbs
  - 8) FORM & INSPECTION PER TEMPLATE DT9649.

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MFG. APPR.	<i>[Signature]</i>	<b>D4108</b>	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		<b>DOUBLERS &amp; FITTINGS</b>	NTS
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**D4108-5F FLAT PATTERN, SMALL RIGHT DOOR DOUBLER**



**D4108-5 SMALL RIGHT DOOR DOUBLER (MAKE FROM D4108-5F)**

**NOTES:**

- 1) MATERIAL -5F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA
- 5 : MAKE FROM D4108-5F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -5: P/N D4108-5 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9649.

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2010-11-30

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MFG. APPR.	<i>[Signature]</i>	<b>D4108</b>	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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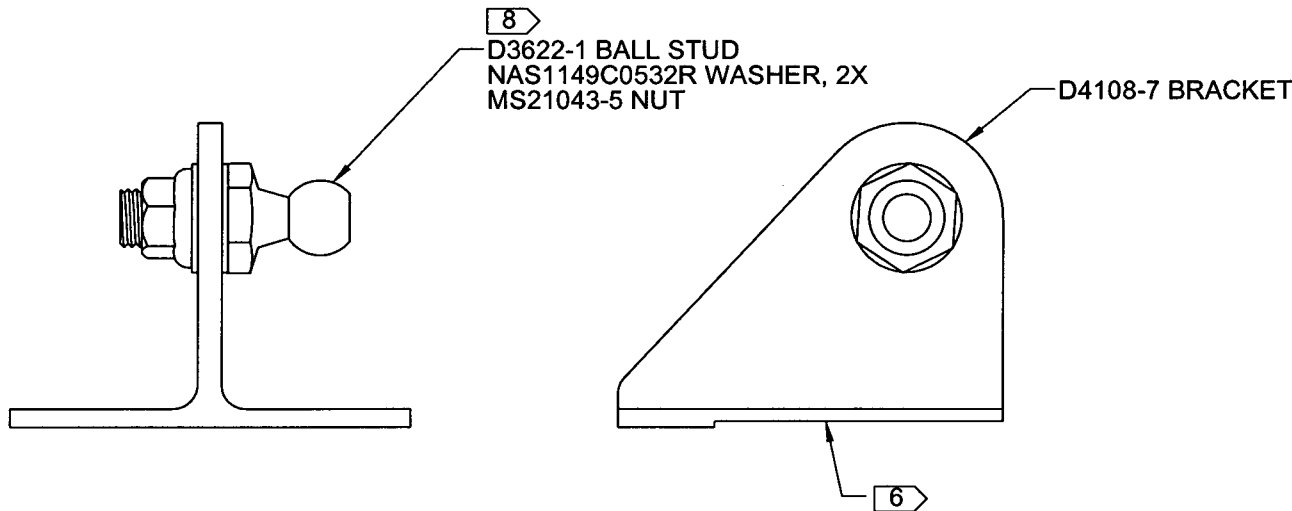
Qty	Part Number	Description
-047		
✕	D4108-047	SILL BRACKET ASSEMBLY
1	D4108-7	BRACKET
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER

D

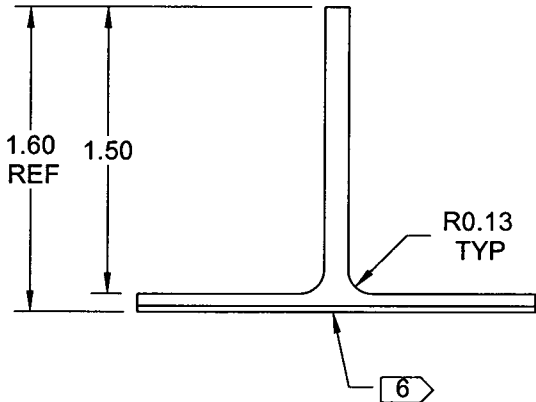
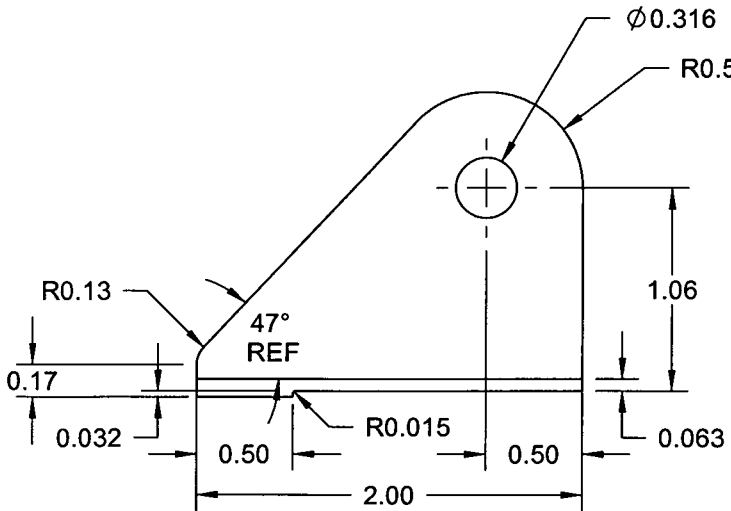
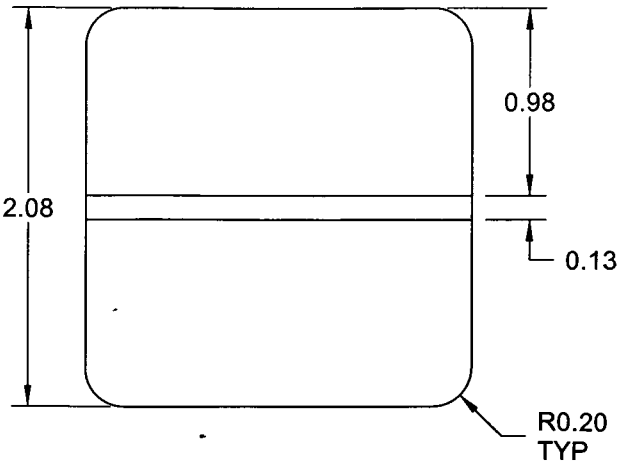
C

B

A



D4108-047 SILL BRACKET ASSEMBLY



GRAIN  
DIRECTION

D4108-7 BRACKET

- NOTES:
- 1) MATERIAL -7: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
  - 7) WEIGHT -047: 0.10 lbs
  - 8) TORQUE TO 5-10 INCH POUND.

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2010-11-30

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MFG. APPR.	<i>[Signature]</i>	D4108	SHEET 5 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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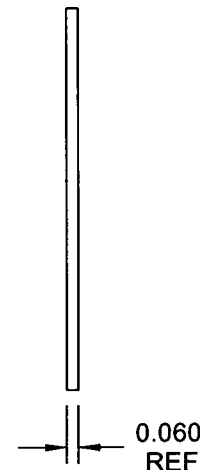
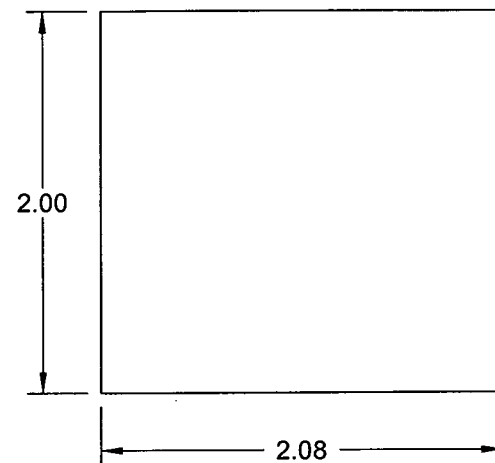
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D

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B

A

**D4108-11 TEMPLATE****NOTES:**

- 1) MATERIAL: LEXAN 9034 SHEET, 0.060 THK  
REF DART MLEXS.060-9034-08  
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.  
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N D4108-11 PER QSI 044 6.1
- 7) WEIGHT: N/A

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MFG. APPR.	<i>[Signature]</i>	SHEET 7 OF 7	
APPROVED	<i>[Signature]</i>	TITLE <b>DOUBLERS &amp; FITTINGS</b>	SCALE NTS
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